

Date: Tuesday, 30/09/2008 8:54:17 AM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: STEP SPACER		
Job Number	: 42344A			Part Number	: D30651		
Estimate Number	: 10375			Drawing Number	: D3065 REV. B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 30/09/2008	S.O. No.	:	Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 15/10/2008		
Previous Run	: 41445A			Qty:	100 50		
Written By	:			Um:	50 Each		
Checked & Approved By	: <u>Jul 08.9.30</u>						
Comment	: Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF						
	Est:D 06.04.25 Water jet			EC			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S040	2024-T3 .040 sheet
		 <b>Comment:</b> Qty.: 0.1300 sf(s)/Unit Total : 6.4995 sf(s) <b>Material:</b> 2024-T3 (QQ-A-250/4) 0.040" thick <b>(M2024T3S.040)</b> <b>Batch:</b> <u>107572</u> <b>HB</b> 8-10-23
2.0	WATER JET	FLOW WATER JET
		 <b>Comment:</b> FLOW WATER JET 1-Cut as per Dwg D3065 Dwg Rev: <u>B</u> <b>HB</b> 8-10-23 Prog Rev: <u>B</u> <b>HB</b> 8-10-23
		 <b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE <u>HB 8-10-23</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 <b>Comment:</b> SECOND CHECK <u>HB 8-10-23</u>
4.0	QC8	SECOND CHECK
		 <b>Comment:</b> SMALL & MEDIUM FAB RESOURCE 1 <u>HB 8-10-23</u>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		 <b>Comment:</b> SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary.

W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 30/09/2008 8:54:17 AM  
User: Julie Lecocq

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 42344A

Part Number: D30651

Job Number:



Seq. #: Machine Or Operation:

Description:

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3065

88 08/10/29 (64)

7.0 QC5 INSPECT WORK TO CURRENT STEP



5 08/10/29 (64) (current)

Comment: INSPECT WORK TO CURRENT STEP

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

90 08-10-30 (64)

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

FD 08/10/30 (64)

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

Sylvie 10/10/30 (64)

11.0 QC21 FINAL INSPECTION/W/O RELEASE



08/10/31 (64)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-10-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	42349
Description: Step Spacer	Part Number:	D3065-1
Inspection Dwg: D3065	Rev: B	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article Prototype

Measured by:	HB
Date:	8-10-23

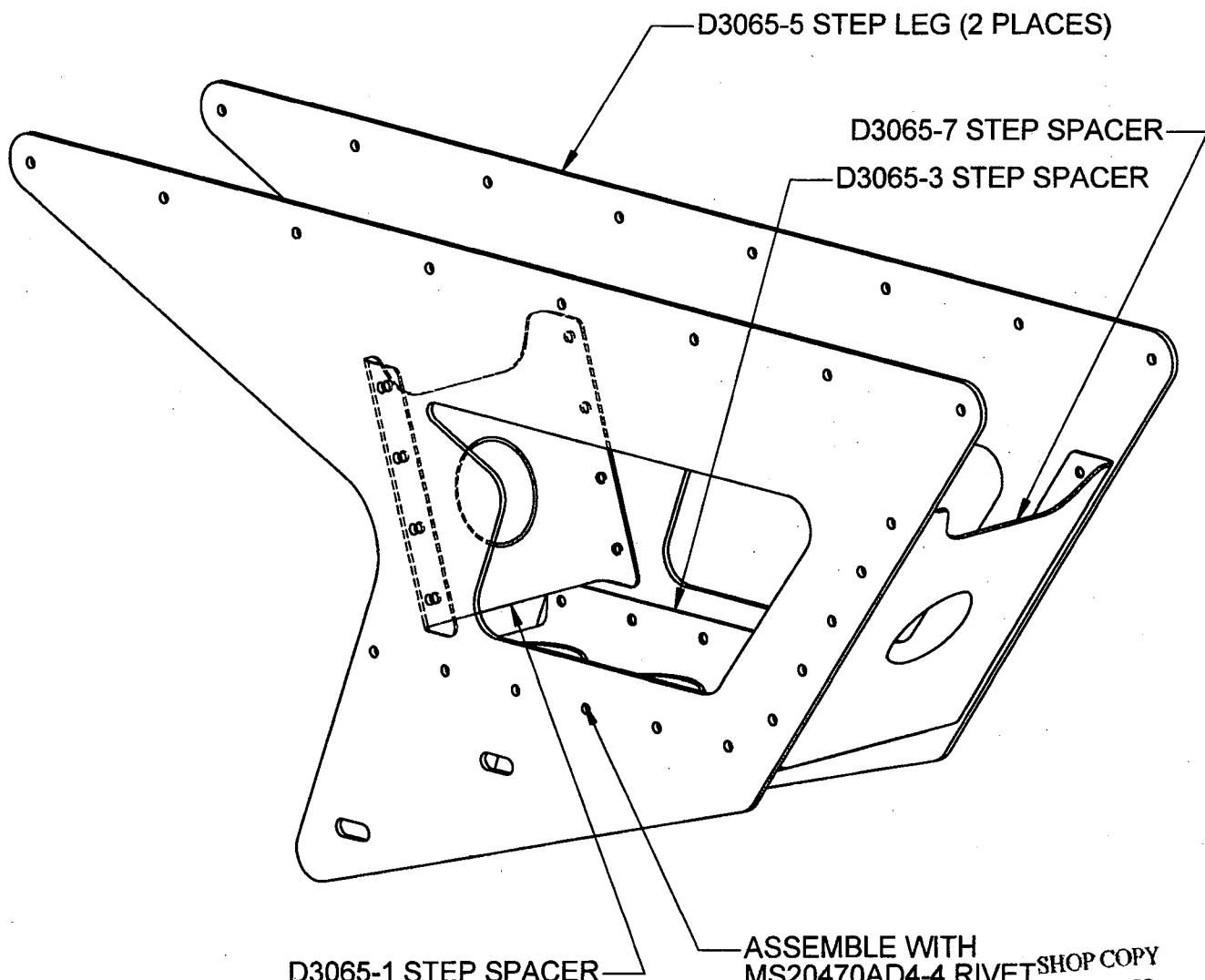
**Audited by:** 6  
**Date:** 06/10/24

Prototype Approval:	<i>N</i>
Date:	<i>1/14</i>

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
B	06.06.23	Dwg Rev. changed	KJ/JLM	
C	07.02.07	Dimension 0.040 added	KJ/JLM	<i>[Signature]</i> <i>[Signature]</i>

**DART**

DESIGN	DRAWN BY	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. <b>D3065</b> REV. B SHEET 1 OF 5
DATE	06.05.23	TITLE <b>STEP LEG ASSEMBLY</b> SCALE 1:2
A	02.09.11	NEW ISSUE
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5

**RELEASED**06.06.20 *CH***D3065-041 STEP LEG ASSEMBLY**

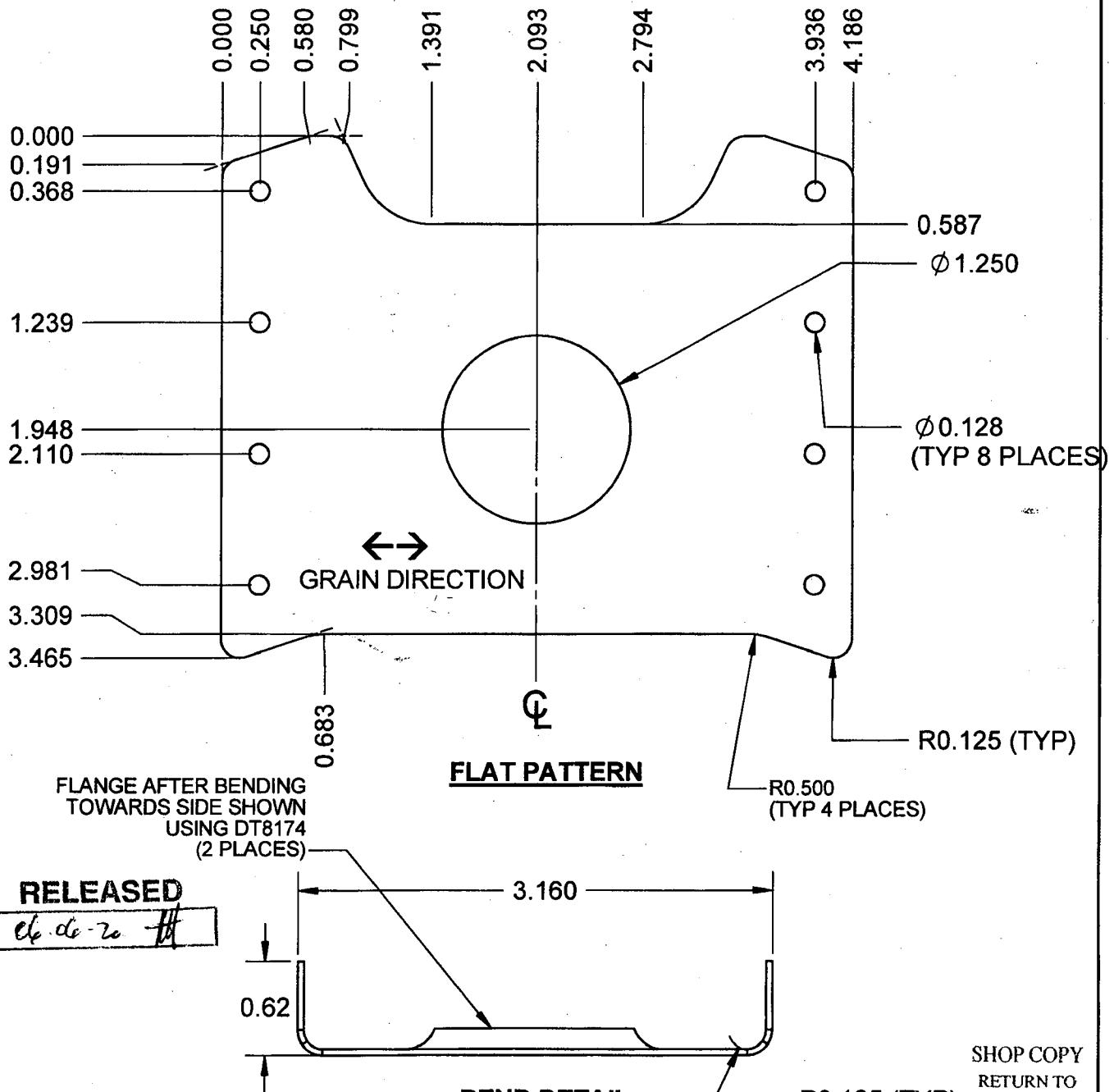
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WORK ORDER  
NO. *42394A*

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PH		D3065	SHEET 2 OF 5
DATE	06.05.23	TITLE	SCALE
		STEP LEG ASSEMBLY	1:1

**D3065-1 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

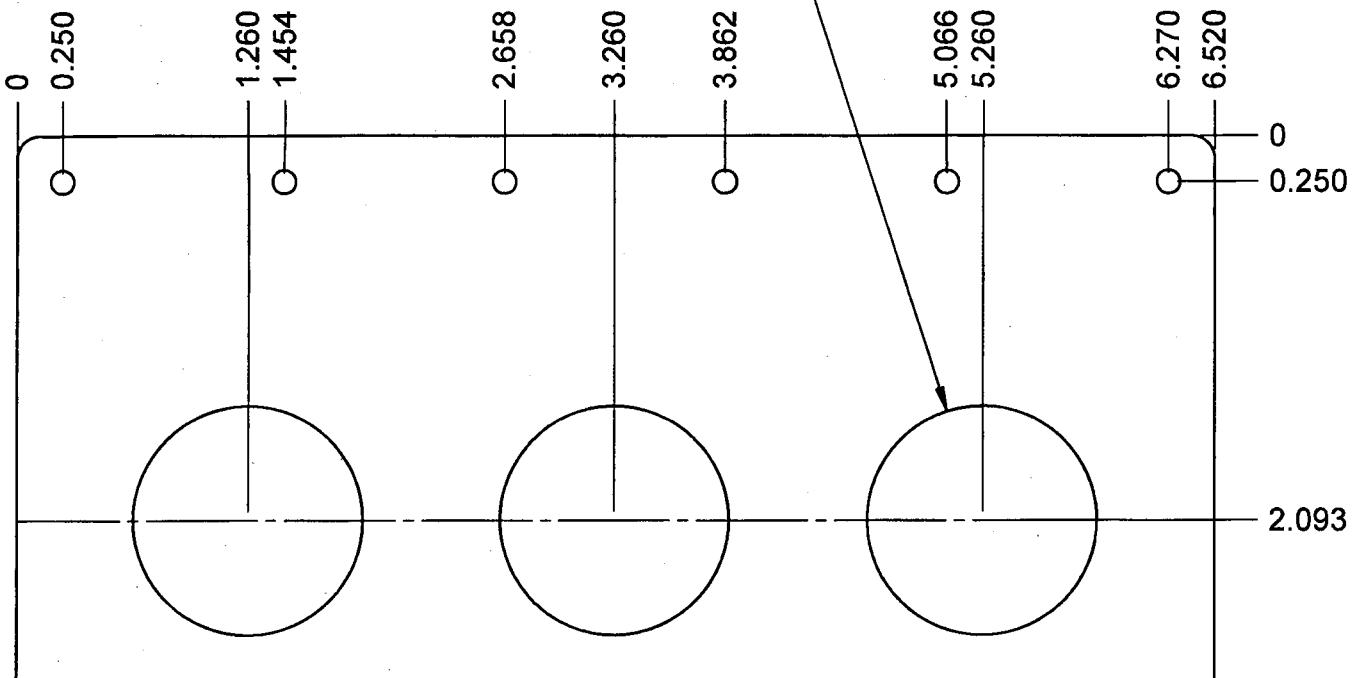
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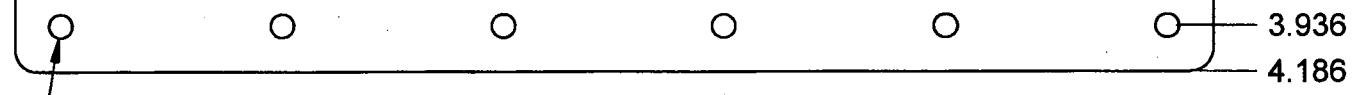
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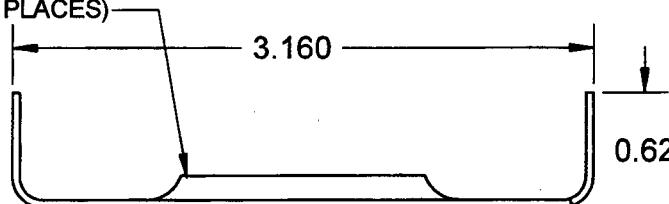
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CHECKED	APPROVED	DRAWING NO. D3065
DATE	06.05.23	REV. B SHEET 3 OF 5 TITLE STEP LEG ASSEMBLY SCALE 1:1

 $\phi 1.250$  (TYP, 3 PLACES)FLAT PATTERN

GRAIN DIRECTION

FLANGE AFTER TOWARDS SIDE  
SHOWN USING DT8174 (3 PLACES) $\phi 0.129$  (TYP, 12 PLACES)

RELEASED

*do not use*BEND DETAIL

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WORK ORDER

NO. *112345***D3065-3 STEP SPACER**

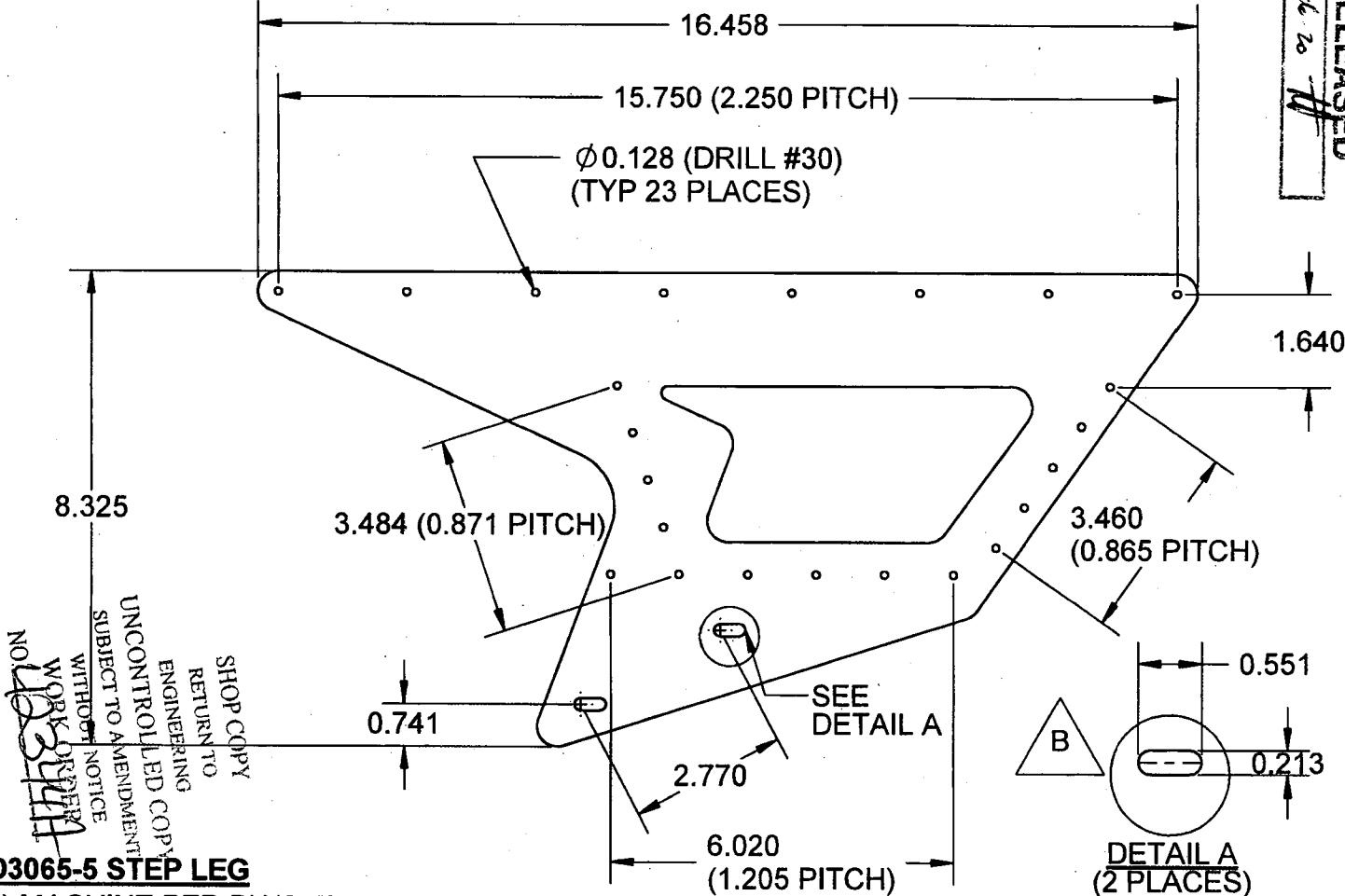
- 1) MATERIAL: 2024-T3 (QQ-A-250/4)  
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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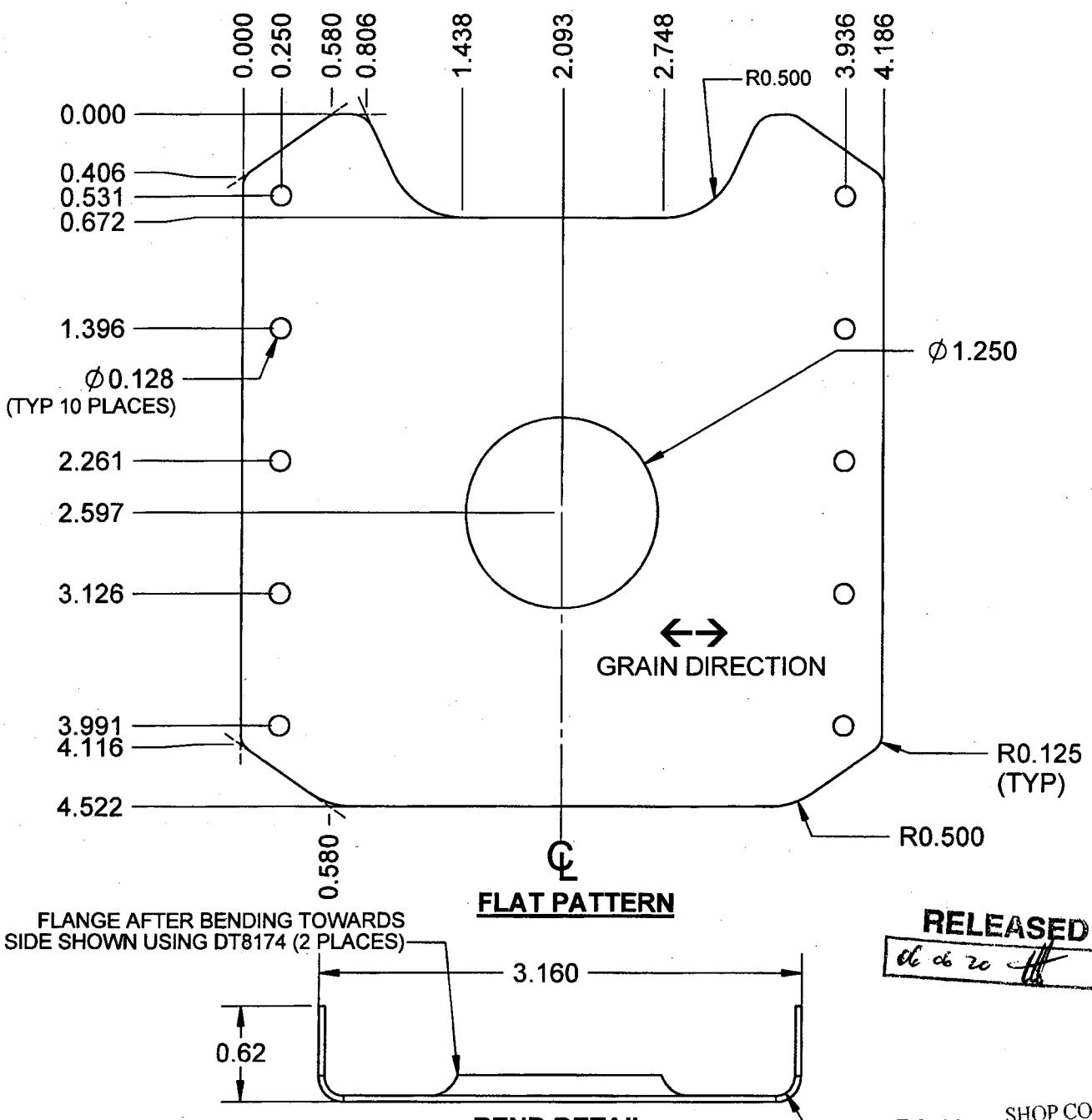
DESIGN	DRAWN BY	DART AEROSPACE LTD
4	C.B	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
PH	W	D3065
DATE	06.05.23	TITLE
		STEP LEG ASSEMBLY
		REV. B
		SHEET 4 OF 5
		SCALE
		1:3

**RELEASED**  
06.06.23**D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)  
OR  
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES



DESIGN <i>IP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3065	REV. B	SHEET 5 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE 1:1	



## **D3065-7 STEP SPACER**

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC.)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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